EAGLE !

Work Order ID 51700

August 28, 2009 6:50:33 AM

Item ID: D3785-3 GY
Revision ID: C
Item Name: Bracket

Accept **Setup Start** **Stop**

Start Date: 8/31/09 **Start Qty:** 5.00
Required Date: 9/11/09 **Req'd Qty:** 5.00
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3785	**Revision Nbr** Rev C					7			
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3785 Dwg Rev: C Prog Rev: C Deburr if necessary	****grain direction 45 degree"**** 2-							
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

6061 . 08C

HB 9-8-31

HB 9-8-31

=> 09/08/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Run Start **Stop**

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
Brake NC	**Memo**	0.00							
Brake NC	Bend as per Dwg D3785								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
150	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	1-counter sink holes as per dwg D3785								

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 51700

August 28, 2009 6:50:33 AM

Item ID: D3785-3 **Accept** **Setup Start**

Revision ID: C **Stop**

Item Name: Bracket

Start Date: 8/31/09 **Start Qty:** 5.00 **Cust Item ID:**

Required Date: 9/11/09 **Req'd Qty:** 5.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
170 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
	Memo M 109091 START TIME: 9:00 AM OVEN TEMPERATURE: 320°F FINISH TIME: 9:30 AM	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 51700

August 28, 2009 6:50:33 AM

Item ID: D3785-3
Revision ID: C
Item Name: Bracket

Accept

Setup Start
Stop

Start Date: 8/31/09 **Start Qty:** 5.00
Required Date: 9/11/09 **Req'd Qty:** 5.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00				5			
QC	**Memo**	0.00							
Quality Control									
200	Identify as per dwg & Stock Location 130	0.00				9/9/15			
Packaging	**Memo**	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00				09/09/16			
QC	**Memo**	0.00							
Quality Control									

9.09.16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 28, 2009 6:50:33 AM

Work Order ID: 51700

Parent Item: D3785-3RevC

Parent Item Name: Bracket

Comments:

Start Date: 8/31/09 **Required Date:** 9/11/09

Start Qty: 5.00 **Required Qty:** 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	270.4990	1.2789	~~1.544~~ 1.790	9-8-31	

6061-T6 .080 Sheet

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	270.499		
107904	0.02		
110254	2.5		
110630	42.9353		
112040	0.0437		
112141	33		
112512	192		112512

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	51700
Description: BRACKET	Part Number:	D3785-3
Inspection Dwg: D3785-3 Rev: C		Page 1 of 1

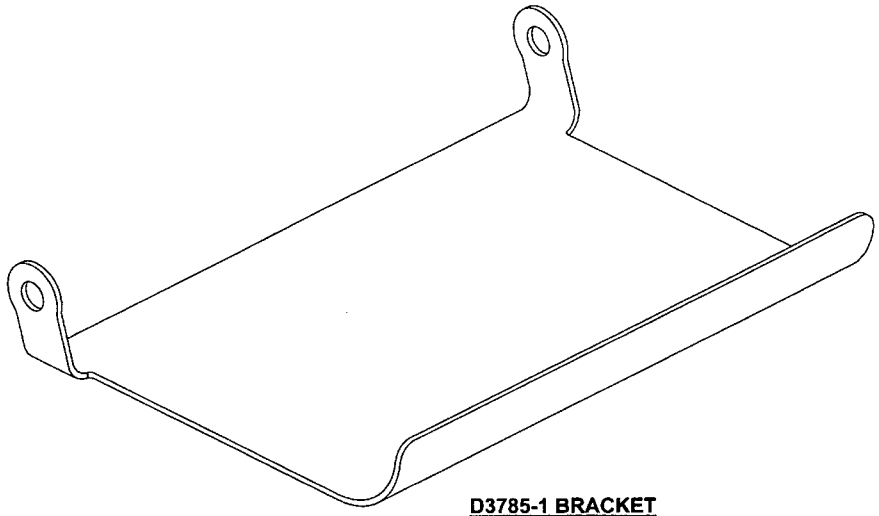
FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

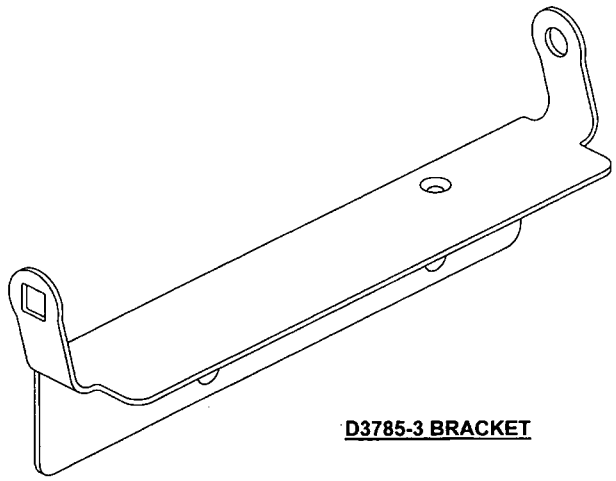
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Ø .201	+.005 -.001	.203	✓			
.405	+/- .010	.406	✓			
.73	+/- .030	.719	✓			
1.255	+/- .010	1.254	✓			
1.435	+/- .010	1.430	✓			
2.259	+/- .010	2.259	✓			
3.134	+/- .010	3.136	✓			
3.51	+/- .030	3.518	✓			
~~1.347~~	~~+/- .010~~					
2.000	+/- .016	2.000	✓			
6.750	+/- .010	6.748	✓			
8.500	+/- .010	8.501	✓			
9.847	+/- .010	9.848	✓			
.080	+/- .010	.076	✓			
.075	+/- .010	.0746	✓			

Measured by:	HB	Audited by:	S	Prototype Approval:	A
Date:	9-8-31	Date:	09/08/31	Date:	9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3785-1 BRACKET



D3785-3 BRACKET

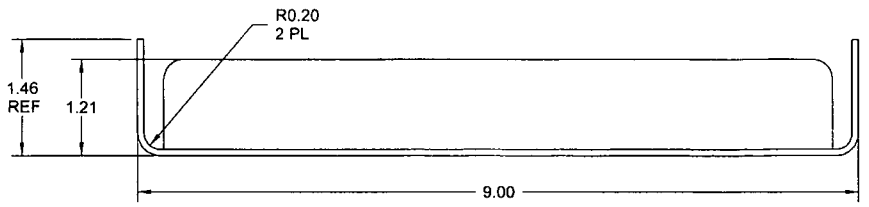
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09-08-31

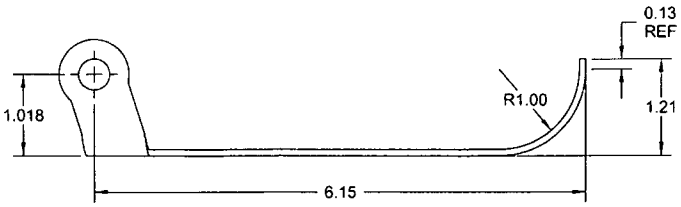
RELEASED
09/07/14 MP

REV.	DESCRIPTION	BY	DATE
C	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.07
B	REDESIGNED D3785-3; REMOVED P/Ns D3785-041/-1/-5/-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29

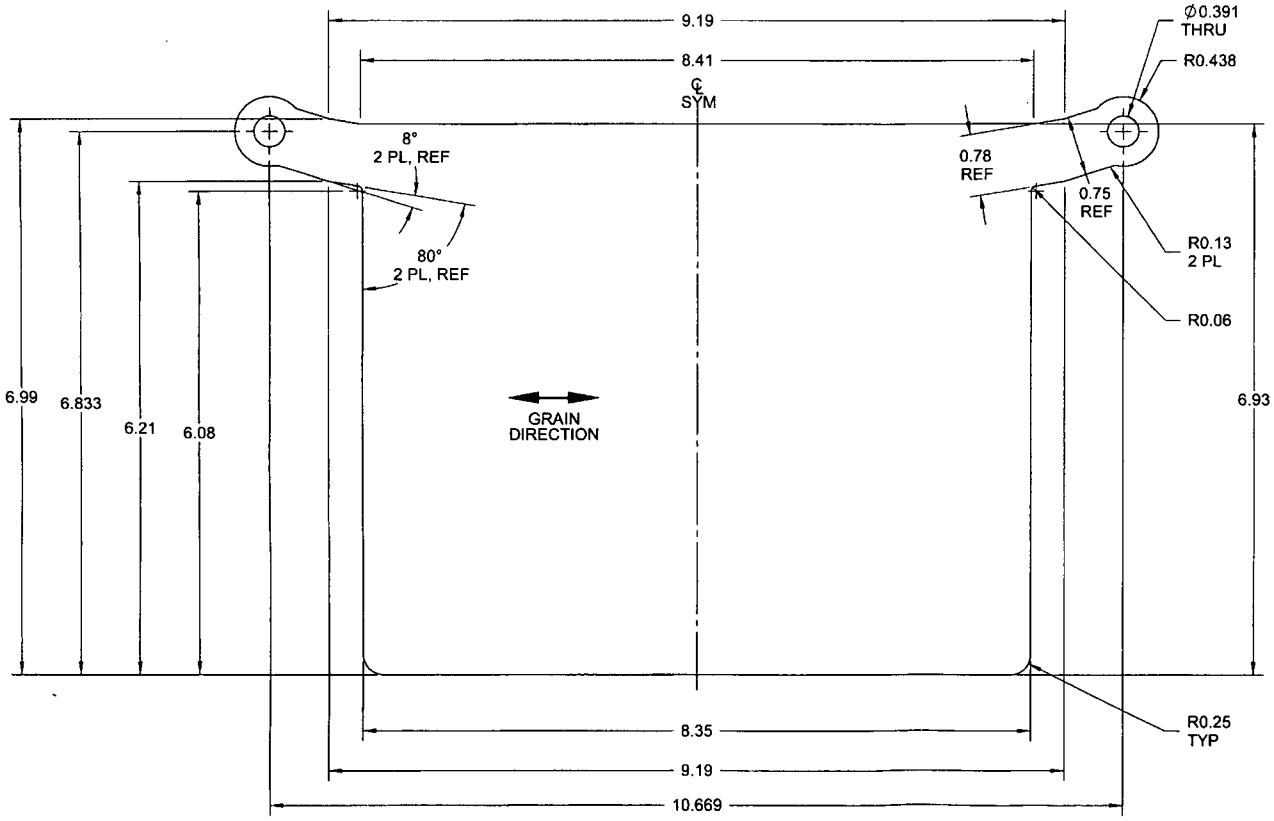
DESIGN	**DART AEROSPACE LTD**	
DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO. D3785	REV. C
MFG. APPR.		SHEET 1 OF 3
APPROVED	TITLE BRACKET	SCALE NTS
DE APPR.		
DATE 09.05.07		

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D3785-1 BRACKET
(MAKE FROM D3785-1F)



D3785-1F BRACKET 1

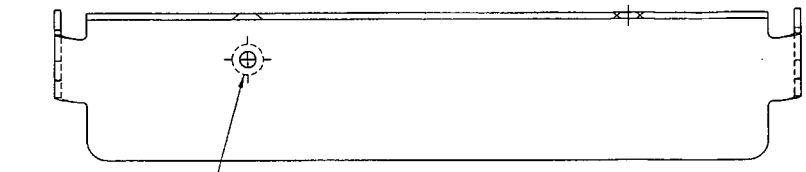
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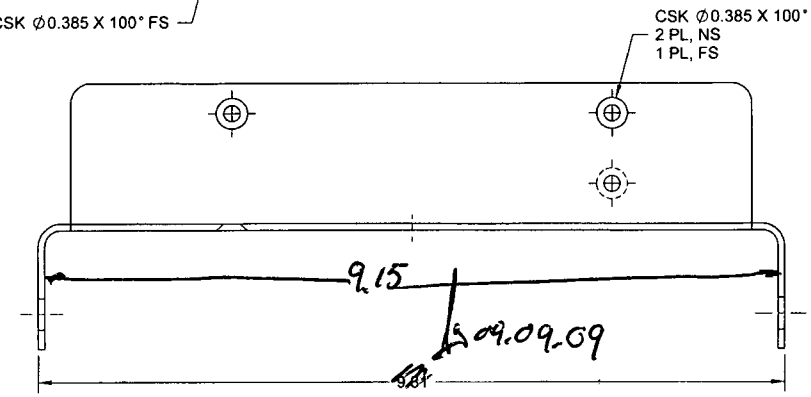
RELEASED
09/07/24 MM

D3785-1 NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.47 lbs

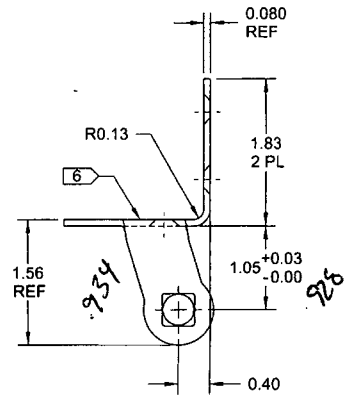
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DRAWN		
CHECKED		DRAWING NO. D3785 REV. C
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 09.05.07		

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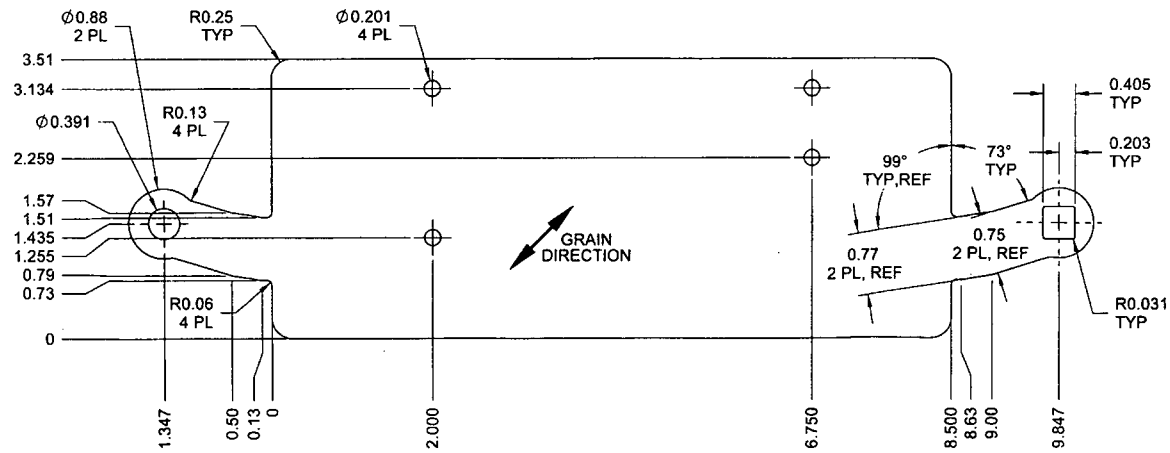




D3785-3 BRACKET
MAKE FROM D3785-3F



51.00 RELEASED 09/07/24 MD



D3785-3F FLAT PATTERN 1

D3785-3 NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-3" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.25 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED	JS	DRAWING NO. D3785 REV. C
MFG. APPR.		SHEET 3 OF 3
APPROVED	MW	TITLE BRACKET SCALE NTS
DE APPR.		
DATE 09.05.07		

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